



Dart Aerospace Ltd.
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Canada

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D2665-1

Job Sheet 208426



Part No: D2665-1

Job Qty: 4 pcs

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	4/13/20		1.00	6.15	HAAS - 1		
							HAAS - 2		
							HAAS - 3		DJP 20-04-04
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	4/13/20		0.00	4.00	Conventional Mill - 1 - B4B		DJP 20-04-04
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	4/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S268477



Part: D2665-1

Job No: 208426

Serial No/Batch: S268477

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/02/20

					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	DIP 20-04-04
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
130 QC 8	4 pcs	4/13/20	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	SI 20-04-05
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	4/13/20	0.00	0.28	Handfinish - 1 - 1 - B4B	BET 20-04-06
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Plex 3/20/20 9:13 AM Dart.lajeunesse.marie	

150 Powdercoat - 1 White Gl(A)-B4B	4 pcs	4/13/20	0.00 0.20	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
160 QC 3	4 pcs	4/13/20	0.00 0.00	Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
170 Packaging 3-1 - Stock - B4B	4 pcs	4/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

20-04-6

BEB 20-04-07

DAS
28
9-89DAS
34
9-89DAS
59
9-89

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	4/13/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
				QC 21 - SA - 70	
				QC 21 - SA - 53	

APR 07 2020

Part Op 100 - HAAS CNC Vertical Machine Program batch number. 1- Inspect part number and batch number are programmed
 Descriptions: correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of
 Folio and visually inspect as per attached Dimension Sheet
 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 235 OVEN TEMPERATURE: 300°
 FINISH TIME: 3:05
 160 - QC3- Inspect Part Finish Standard Process
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	3x 3229059 1x 5240460

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	36	0

Part Specifications

Specifications could not be found.

Plex 3/20/20 9:13 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 208426
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1
Inspection Dwg: D2665	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	0.119	0.1195	0.1195	
B	0.100	0.140		.128	0.127	0.128	0.128	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		.650	0.660	0.660	0.660	
E	0.240	0.260		.250	0.250	0.248	0.248	
F	1.313	1.343		1.322	1.322	1.322	1.322	
G	0.210	0.230		.220	0.220	0.220	0.220	
H	0.100	0.180		.130	0.127	0.127	0.128	
I	2.470	2.510		2.492	2.495	2.495	2.495	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		.127	0.120	0.115	0.115	
M	0.990	1.010		.995	1.000	1.000	1.000	
N	0.510	0.515		0.511	0.511	0.511	0.511	
O	5.990	6.010		6.002	6.003	6.003	6.003	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		.315	0.313	0.313	0.313	
S	0.315	0.322		.318	0.319	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		.795	0.797	0.797	0.797	
W	0.540	0.560		.548	0.549	0.550	0.551	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.258	.258	.258	.258	
Z	0.912	0.932		.921	0.923	0.923	0.923	
AA	0.490	0.510		.500	0.499	0.499	0.500	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: DJP	Date: 20-04-04
Audited by: DAS	Date: 20-04-05
Prototype Approval: 20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					